

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020910**Date Inspected:** 18-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Liu hau jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG Assembly Bay- 14.

This QA Inspector randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW) repair welding of grillage plate weld joint identified as SA7512C-256. Welder is identified as 047864. ZPMC Quality Control (QC) is identified as Mr.Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with Welding Procedure Specification (WPS): WPS-345-SMAW-1G (1F)-FCM-repair. The repair welding was being performed as per Critical Welding Repair Report (CWR) No: B-CWR2629 Rev.No.3. This weld was previously rejected by ZPMC QC personnel and recorded on UT report B787-UT-18524R3.

SMAW welding of weld joint identified as SEG3020BB-064. Welder is identified as 045246. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC personnel observed appeared to comply with Welding Procedure Specification (WPS): WPS-345-SMAW-2G (2F)-FCM-repair. The repair welding was being performed as per CWR No: B-CWR2752.This weld was previously rejected by ZPMC QC personnel and recorded on UT report B787-UT-18580R1.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

SMAW welding of weld joint identified as SEG3020BB-046. Welder is identified as 067942. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC personnel observed appeared to comply with Welding Procedure Specification (WPS): WPS-345-SMAW-2G (2F)-FCM-repair. The repair welding was being performed as per CWR No: B-CWR2752. This weld was previously rejected by ZPMC QC personnel and recorded on UT report B787-UT-18580R1.

Flux Cored Arc Welding (FCAW) welding of weld joint identified as SEG3020BB-113. Welder is identified as 066695. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-T-2233-ESAB.

American Bridge /Fluor (AB/F) QA Inspector was performing Magnetic Particle Testing (MT) on weld back gouged area for the weld joint identified as SEG3020BB-116. Refer the attached photos for reference.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhu,Surendra	Quality Assurance Inspector
----------------------	-----------------	-----------------------------

Reviewed By:	Peterson,Art	QA Reviewer
---------------------	--------------	-------------
